

Date: Thursday, 1/17/2008 3:31:54 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LITTER DECKPLATE 350		
Job Number	: 36850		Part Number	: D2344		
Estimate Number	: 10357		Drawing Number	: D2344 REV F		
P.O. Number	:		Project Number	: N/A		
This Issue	: 1/17/2008	S.O. No. :	Drawing Revision	: F		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type :	Due Date	Qty:	10	Um: Each
Previous Run	: 33262					
Written By	:					
Checked & Approved By	: 10/08 01 18					
Comment	: Est Rev:D 00.06.26 Removed P/O for powder coat EC Est Rev:E 07-07-04 Asper Rev F JLM*					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S063	2024-T3 .063 sheet
Comment: Qty.: 0.7823 sf(s)/Unit Total : 7.8225 sf(s) Material: 2024-T3 QQ-A-250/5) .063 Batch 106223 <i>IR 8-1-21</i>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		<i>(10)</i>
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
		<i>(10)</i>
Comment: SECOND CHECK		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL/MED FAB		
1-Deburr sharp edges <i>IR 8-1-21</i>		
2-Countersink holes per Dwg D2344 <i>IR 8-01-25 (10)</i>		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/02/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: LITTER DECKPLATE 350

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



✓ 08/01/08 (10)

Comment: INSPECT WORK TO CURRENT STEP

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

✓ 08-01-28 (10)

8.0 POWDER COATING

POWDER COATING



M100708

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

✓ 08-01-3, (10)

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

✓ 08-01-3, (10)

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: Identify and Stock

Location: ST185

✓ AS 08/02/01 (10)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

✓ 08-02-04 (10)

Job Completion



✓ 2008/2/04 (10)

✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36850
Description: Litter Deck Plate Kit (350)	Part Number:	D2344
Inspection Dwg: D2344 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

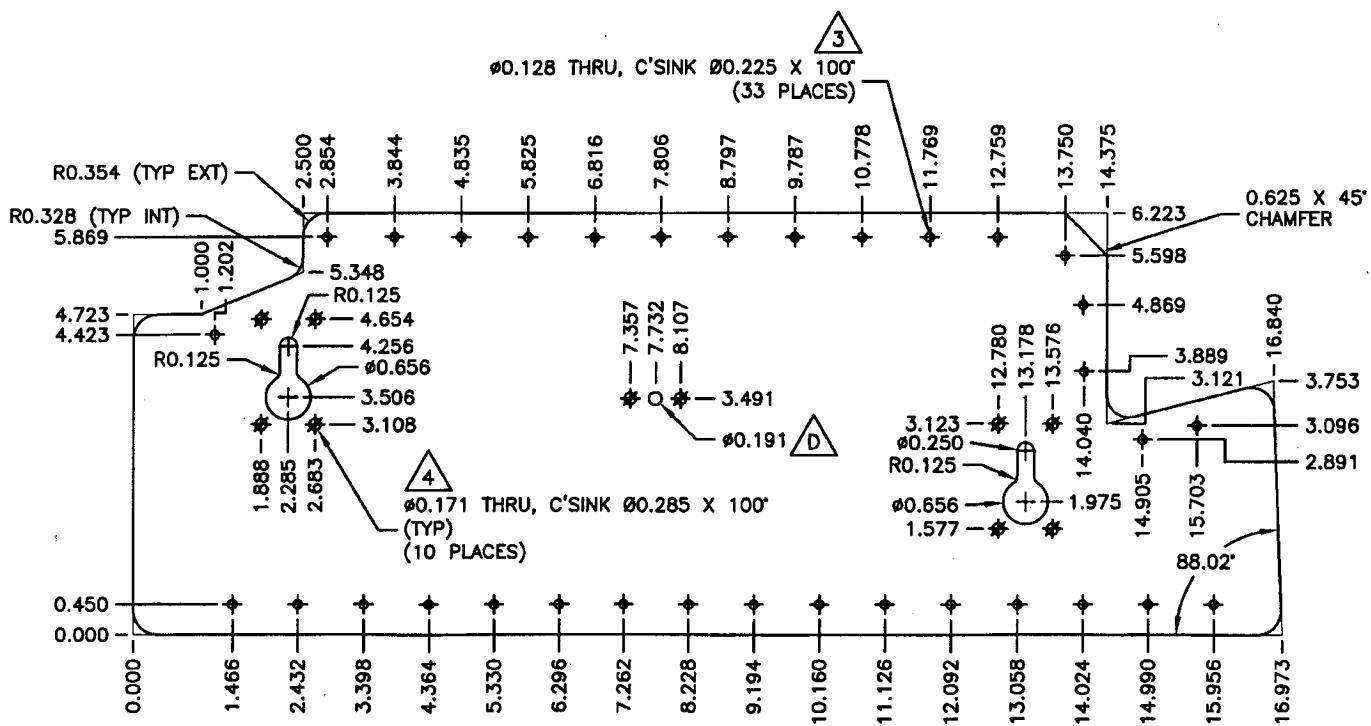
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.223	+/-0.010	6.225	X			
5.598	+/-0.010	5.598	X			
4.869	+/-0.010	4.869	X			
3.889	+/-0.010	3.889	X			
3.096	+/-0.010	3.096	X			
2.891	+/-0.010	2.891	X			
16.973	+/-0.010	16.973	X			
0.450	+/-0.010	.450	X			
4.423	+/-0.010	4.423	X			
4.723	+/-0.010	4.723	X			
1.202	+/-0.010	1.202	X			
5.869	+/-0.010	5.871	X			
4.654	+/-0.010	4.654	X			
Ø0.656	+0.005/-0.000	.657	X			
1.888	+/-0.010	1.888	X			
2.285	+/-0.010	2.285	X			
2.683	+/-0.010	2.683	X			
Ø0.171	+0.005/-0.000	.176	X			
3.491	+/-0.010	3.493	X			
Ø0.191	+0.005/-0.000	.196	X			
3.123	+/-0.010	3.124	X			
1.975	+/-0.010	1.975	X			
Ø0.128	+0.005/-0.001	.133	X			

Measured by:	LB	Audited by:	AS	Prototype Approval:	N/A
Date:	8-1-21	Date:	08/06/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	07.09.06	Dimensions updated per Dwg. Rev. F	KJ/JLM	LB

DART

DESIGN KE	DRAWN BY <i>JL</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>AB</i>	APPROVED <i>HH</i>	DRAWING NO. D2344	REV. F SHEET 1 OF 1
DATE 07.06.07		TITLE LITTER DECK PLATE, 350	SCALE 1:3
A	95.01.14	NEW ISSUE	
B	95.02.09	MOVED KEY HOLES	
D	95.03.06	0.191 WAS 0.197	
E	98.06.19	0.063–0.071 THICK WAS 0.071 (TSR A371)	
F	07.06.07	C'SINK Ø0.285 WAS Ø0.308	



D2344 LITTER DECK PLATE, 350

1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063–0.071 THICK PER QQ-A-250/4
 (REF. DART SPEC. M2024T3S)
 2) FINISH: POWDER COAT BLACK SANTEX (REF. 4.3.5.7) PER DART QSI 005 4.3
 3) COUNTERSINK HOLES MARKED \diamond TO Ø0.225 X 100'
 4) COUNTERSINK HOLES MARKED \diamond TO Ø0.285 X 100'
 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 8) IDENTIFY WITH DART P/N "D2344" USING WHITE PAINT MARKER

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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO 36850

RELEASED

07.06.22 *HH*

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